

Work Order ID 119397

Thursday, May 15, 2014 3:54:36 PM

119397

Page 1

Item ID: D3457-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 5/15/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJDate: 14-05-21

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100		0.00							DAS 40 9-89
-----	--	------	--	--	--	--	--	--	-------------------

100

DOOSAN LATHE

Doosan

Doosan Lathe

Memo

0.00

24 Ø

14/06/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS
40
9-89***110***

QC

Quality Control

Memo

0.00

24 Ø

14/06/10

120

QC8- Inspect parts - second check

0.00

DAS
20
9-89***120***

QC

Quality Control

Memo

0.00

24 Ø

14-06-11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
	Crushing	Countersink	Misaligned/off center	Positioned Wrong						
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other					
	Inspection Strip in Tube	Drawing	Misread							
	Marks/Chatter	Drill Holes	Off-set							
	Turning Sequence	Finish	Out of Calibration							
	Wave/Twist in Tube	Fit/Function	Out of Sequence							

Work Order ID 119397

Thursday, May 15, 2014 3:54:36 PM

119397

Page 2

Item ID: D3457-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 5/15/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

130

Identify as per dwg & Stock Location.

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Packaging

Packaging

Memo

0.00

24X

146-11

DAS

26

9.89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MLJ 14-06-17

DD 14-6-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only 

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	Bend	Folio/Program	Outside Dimensions			Pressure/Forced				
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance			Set-up				
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect			Temperature/Cure				
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing			Weld				
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved			Wrong Stock Pulled				
	Crushing	Countersink	Misaligned/off center	Positioned Wrong							
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge							
	Inspection Strip in Tube	Drawing	Misread								
	Marks/Chatter	Drill Holes	Off-set								
	Turning Sequence	Finish	Out of Calibration								
	Wave/Twist in Tube	Fit/Function	Out of Sequence								

Picklist Print

Thursday, May 15, 2014 3:54:40 PM

Page 1

Work Order ID: 119397

119397

Parent Item: D3457-1

D3457-1

Parent Item Name: Washer

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A05.10.03 New issue KJ/JLM

IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	15.9542	0.0208	1			DAS 40 9-89

MDFI RINR1 000

Delrin Round Bar 1" color: black

Location	Loc Qty	Loc Code
MAT039	15.95421	
→ m127442	7.95421	
m128667	8	1.0

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging	Engineering Quality Other				
Part No. _____						Supplier					
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

DART AEROSPACE LTD	Work Order:	119397
Description: Washer	Part Number:	D3457-1
Inspection Dwg: D3457	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

—BAS

Measured by:	DAS 40	Audited by:	20 9-89	Prototype Approval:	N/A
Date:	14/06/10	Date:	14-06-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/EC	

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

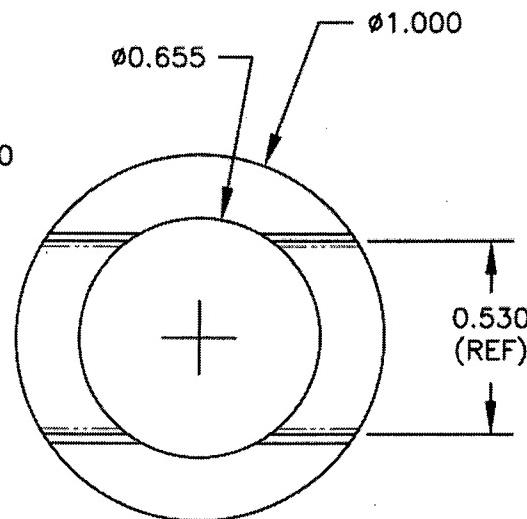
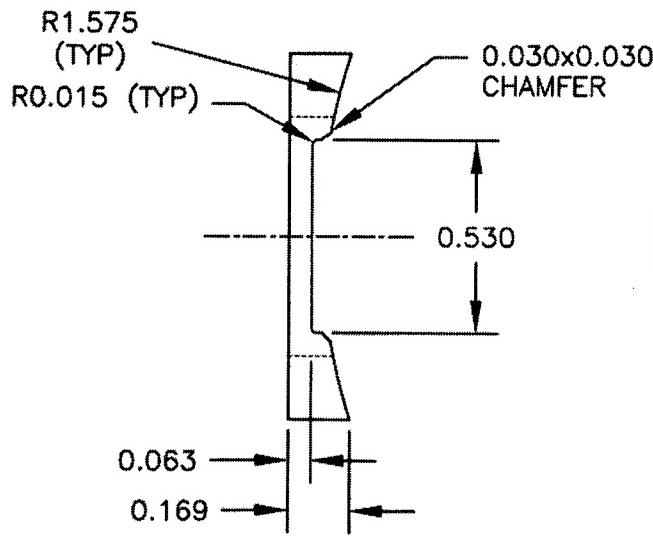
QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending			Bend <input type="checkbox"/>		Folio/Program <input type="checkbox"/>			Outside Dimensions <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>	
Centre Not Concentric			BOM/Route <input type="checkbox"/>		Grain <input type="checkbox"/>			Over/Under tolerance <input type="checkbox"/>		Set-up <input type="checkbox"/>	
Cracks			Broken/Damage/Defect <input type="checkbox"/>		Hardware <input type="checkbox"/>			Part Incorrect <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>	
Crimp/Kink/Ripple/Wave			Burrs <input type="checkbox"/>		Inspection Incomplete/Unqualified <input type="checkbox"/>			Part Lost/Missing <input type="checkbox"/>		Weld <input type="checkbox"/>	
Cuffs			Contamination <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>			Part Moved <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>	
Crushing			Countersink <input type="checkbox"/>		Misaligned/off center <input type="checkbox"/>			Positioned Wrong <input type="checkbox"/>			
Heat Treat			Cut Too Short <input type="checkbox"/>		Mislabeled <input type="checkbox"/>			Power Loss/Surge <input type="checkbox"/>			
Inspection Strip in Tube			Drawing <input type="checkbox"/>		Misread <input type="checkbox"/>						
Marks/Chatter			Drill Holes <input type="checkbox"/>		Off-set <input type="checkbox"/>						
Turning Sequence			Finish <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>						
Wave/Twist in Tube			Fit/Function <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>						

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

RELEASED
05.09.06 *[initials]***ISOMETRIC DETAIL****D3457-1 WASHER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119301 *[initials]* MJS
14-05-21

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: Part No. NCR No.	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							